

Work Order ID 53946

November 23, 2009 3:00:50 PM

Page 1

Item ID: D3302-3

Accept



Setup Start



Revision ID: B2

Stop



Item Name: Doubler

Start Date: 23/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *BA*

Date: *09-11-23*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3302

Rev B2

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3302
Deburr if necessary

☐ Dwg Rev: *B2*

☐ Prog Rev: *B2*

☐ 2-

B 9-12-7

(6)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-12-7

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) 8 01/12/07

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53946

November 23, 2009 3:00:50 PM



Page 3

Item ID: D3302-3

Accept



Setup Start



Revision ID: B2

Stop



Item Name: Doubler

Start Date: 23/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	BR 10-01-14			⑥			
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	JU 10-01-14			⑥			
180 Packaging Packaging	Identify as per dwg & Stock Location: <u>51</u> Memo	0.00 0.00				10-1-4			QSP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

November 23, 2009 3:00:50 PM



Accept

**Setup Start**

Stop

**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

**Draw
Number**

Draw
Rev.

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Number Stamp
_____ *[Signature]*
MF ~~*09-01-04*~~
10-01-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

November 23, 2009 3:00:56 PM

Work Order ID: 53946



Parent Item: D3302-3RevB2



Parent Item Name: Doubler

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

210.0499

6.2722



B 9-12-7

6061-T6 .063 Sheet

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

MAT

210.0499211

110551

31.0341211

112939

179.0158

112939

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

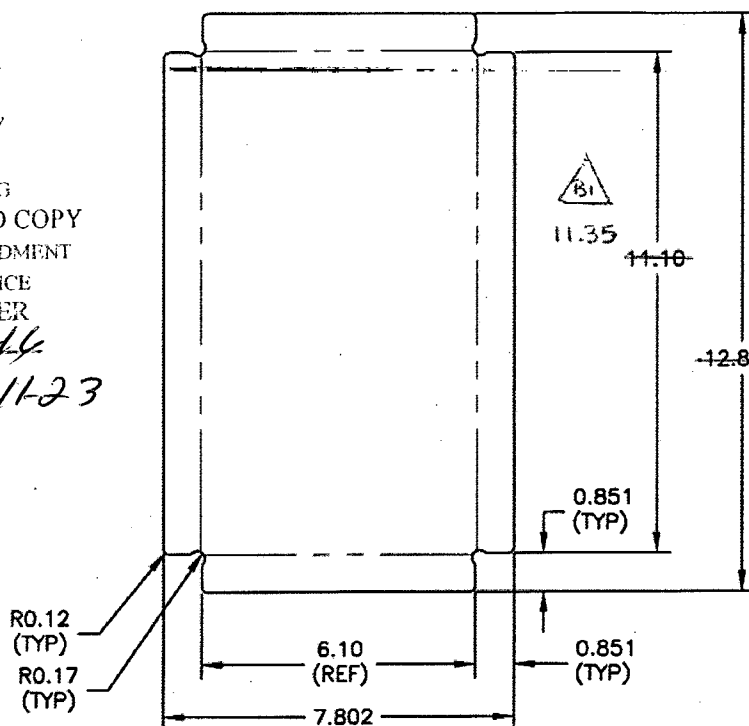
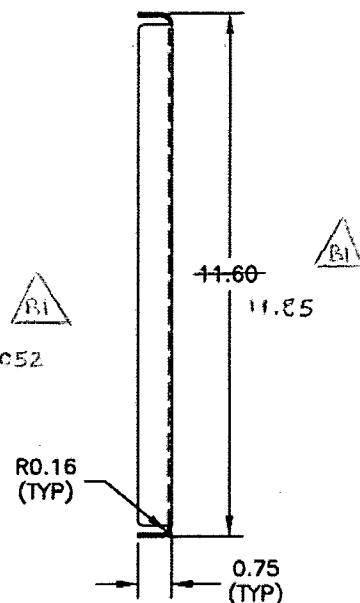
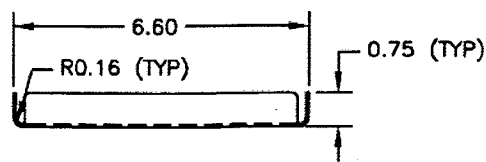
DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3302	REV. B SHEET 1 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4
A	04.07.06	NEW ISSUE	
B	04.11.18	REMOVE HOLES	
B1	RF 04.12.15	ADDED 0.25" TO THE LENGTH FOR -1/-3	
B2	RF 05.03.21	7.25 WAS 7.34 ; 8.952 WAS 9.042 ; 7.75 WAS 7.84 FOR D3302-3	

RELEASED
04.11.23

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53944

BT 09-11-23

**D3302-1 FLAT PATTERN****D3302-1 DOUBLER
BEND DETAIL****D3302-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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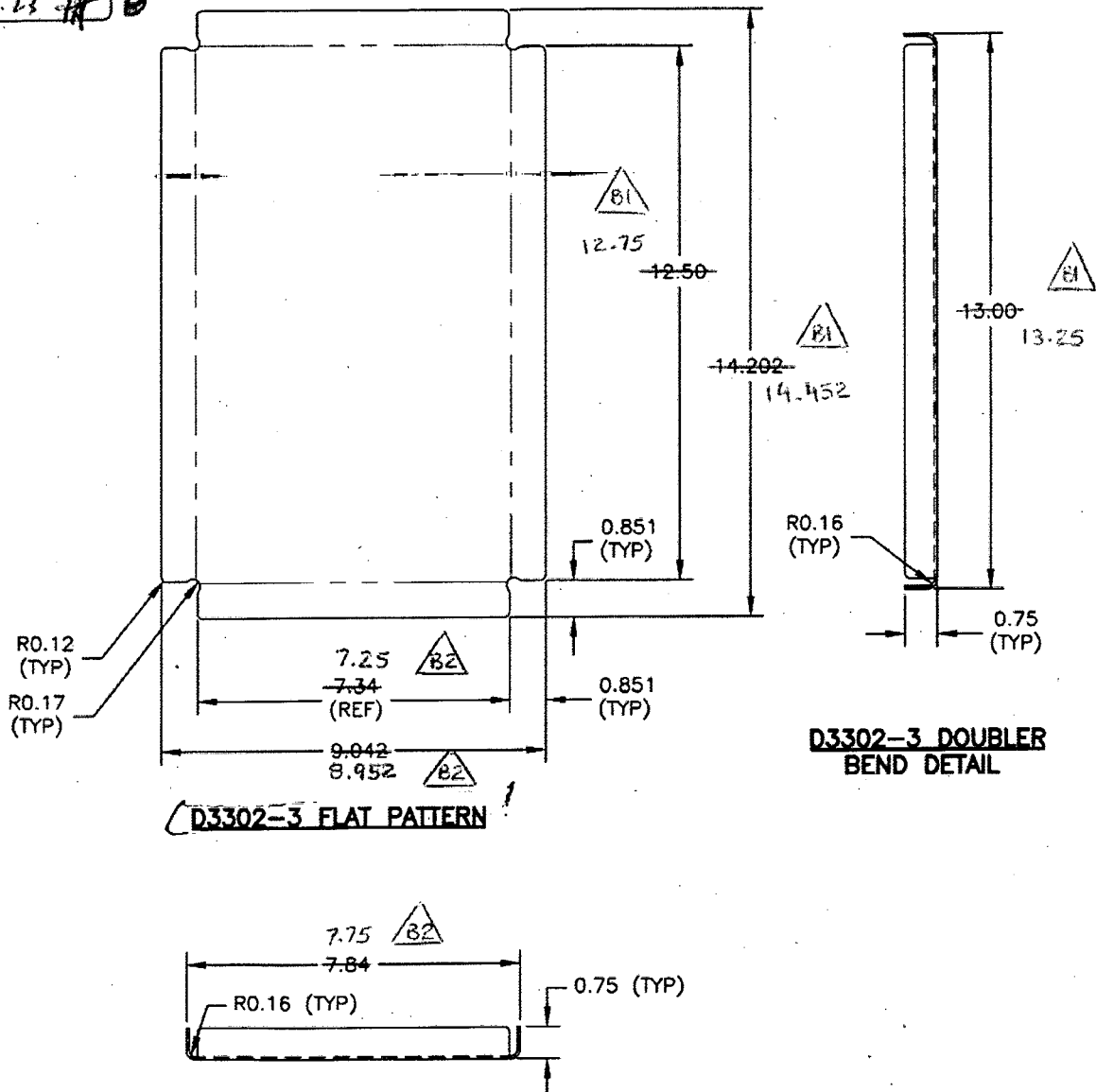
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4

RELEASED
04.11.23

W10 53946

**D3302-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

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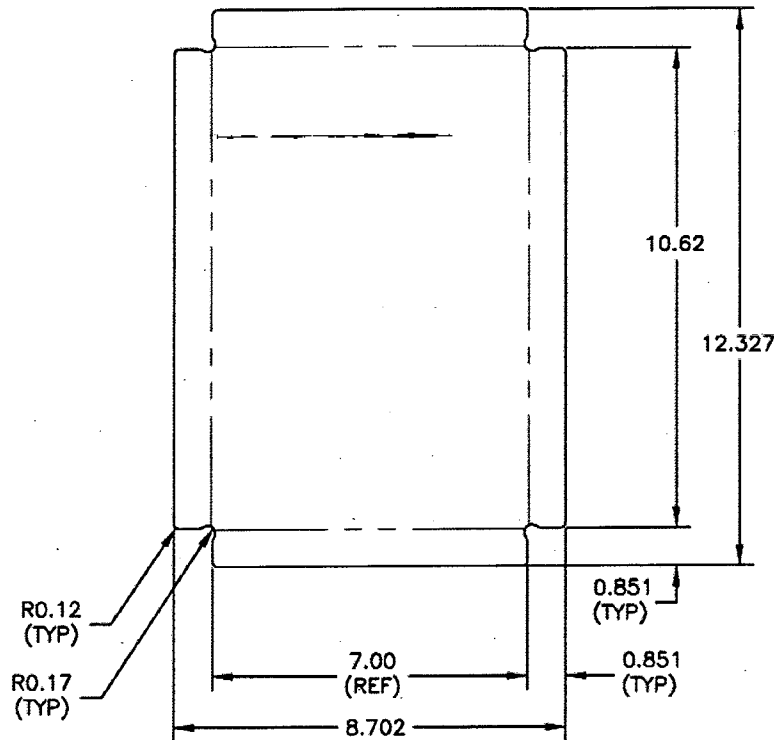
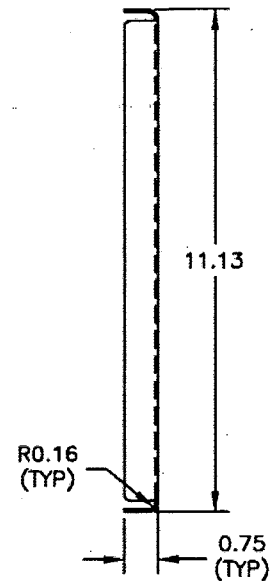
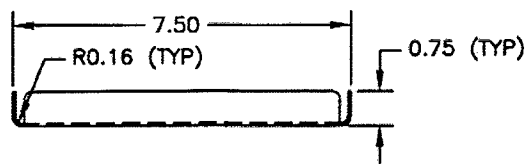
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3302	REV. B SHEET 3 OF 4
DATE 04.11.08		TITLE DOUBLER	SCALE 1:4

RELEASED
04.11.23 H

W10 53944

**D3302-5 FLAT PATTERN****D3302-5 DOUBLER
BEND DETAIL****D3302-5 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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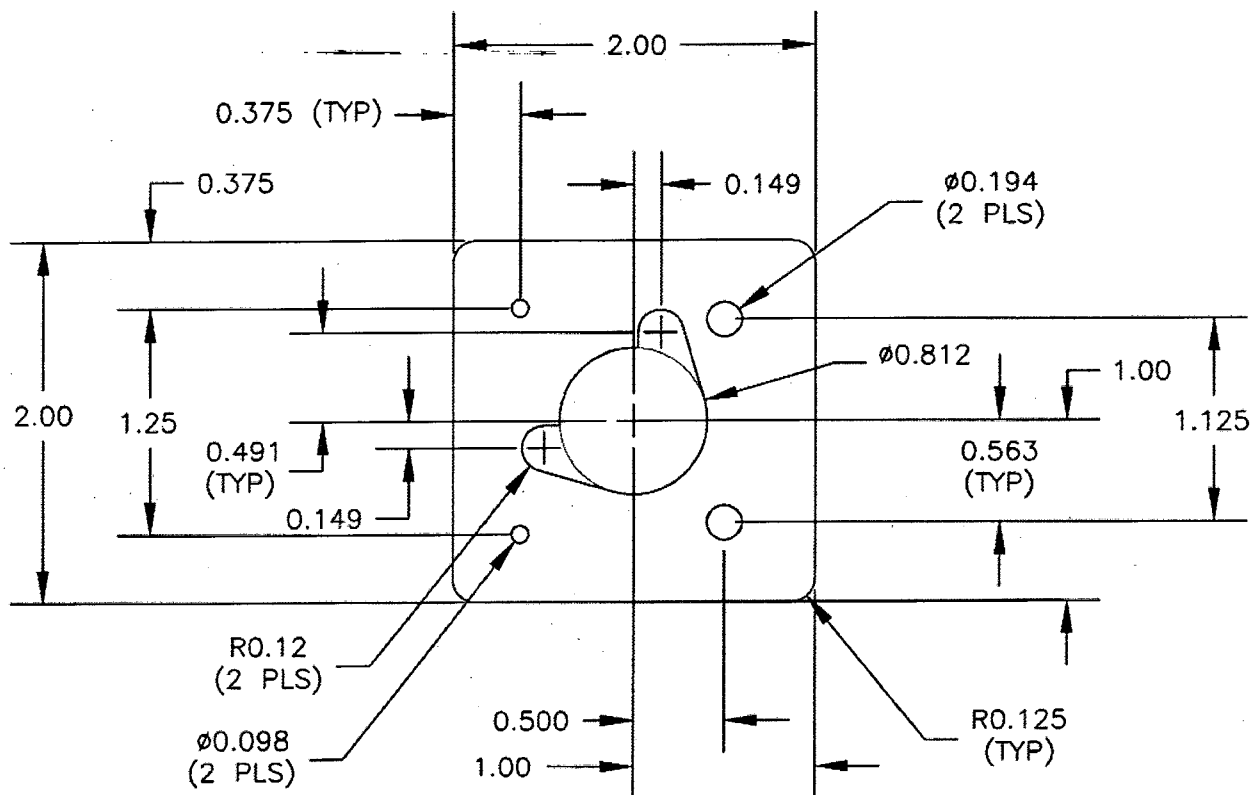
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3302	REV. B SHEET 4 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:1

RELEASED
04.11.23

W1053946

**D3302-7****D3302-7 NOTES:**

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11)
0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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DART AEROSPACE LTD		Work Order:	53946
Description: Doubler		Part Number:	D3302-3
Inspection Dwg: D3302 Rev: B2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.452	+/-0.010	14.452	✓			
12.75	+/-0.030	12.75	✓			
0.851	+/-0.010	0.851	✓			
0.851	+/-0.010	0.852	✓			
8.952	+/-0.010	8.952	✓			
R0.12	+/-0.030	0.12	✓			
7.250	+/-0.010	7.250	✓			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-12-7	Date: 09/12/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev update; Dimensions revised to revision B2	KJ/JLM	
C	07.01.16	Dimensions revised	KJ/JLM	
D	07.01.29	Dimensions revised	KJ/JLM	